

Date: Tuesday, 10/23/2007 3:11:05 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	: SUPPORT BRACKET	
Job Number	35328					
Estimate Number	10260					
P.O. Number	N/A			Part Number	: D23623	
This Issue	10/23/2007	S.O. No.	N/A	Drawing Number	: D2362 REV E1	
Prsht Rev.	NC			Project Number	: N/A	
First Issue	N/A	Type	MACHINED PARTS	Drawing Revision	: E1	
Previous Run	34292			Material	: N/A	
Written By				Due Date	: 11/25/2007	
Checked & Approved By	<i>JL 07.10.23</i>			Qty:	15	
Comment	Est: G 00.05.18 Added inspection level 8 EC			Um:	EA	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2265	Step Support Casting	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) Step Support Pick: Qty Part Number Description Batch	<i>29807</i>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: Machine per folio D2362-3	<i>JL 07/11/28</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: Inspect Level 2	<i>JL 07/11/28</i>
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<i>8F 07/12/02</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr	<i>SB 07/12/04</i>
6.0	POWDER COATING	POWDER COATING	
		Comment: POWDER COATING Powder Coat Gloss White (Ref 4.3.5.1)as per Dart QSI 005 4.3	<i>EL 07/12/04</i>

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 8/10/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/23/2007 3:11:05 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT BRACKET

Job Number: 35328

Part Number: D23623

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(ISX)

M-L

07/12/04

Comment: INSPECT POWDER COAT

8.0 D23971

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Rubber Cushion

Pick:



Qty Part number Description Batch

1 D23971 Rubber

B30971 X13mx, B36117 x 2mx

9.0 D23973

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Rubber Cushion

Pick:



Qty Part number Description Batch

1 D23973 Rubber

B30972 X13mx, B36118 x 2mx

10.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond rubber D2397-1 followed by D2397-3 using contact cement
as per Dwg D2362

Batch M102865

mf 07-12-10

(IS)

11.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

(✓) 07/12/10 (XIS) counts

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: ST478

(✓)

AS 07/12/10

(XIS)

13.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(✓) 07/12/11

Job Completion



U 07/12/11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
.								

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

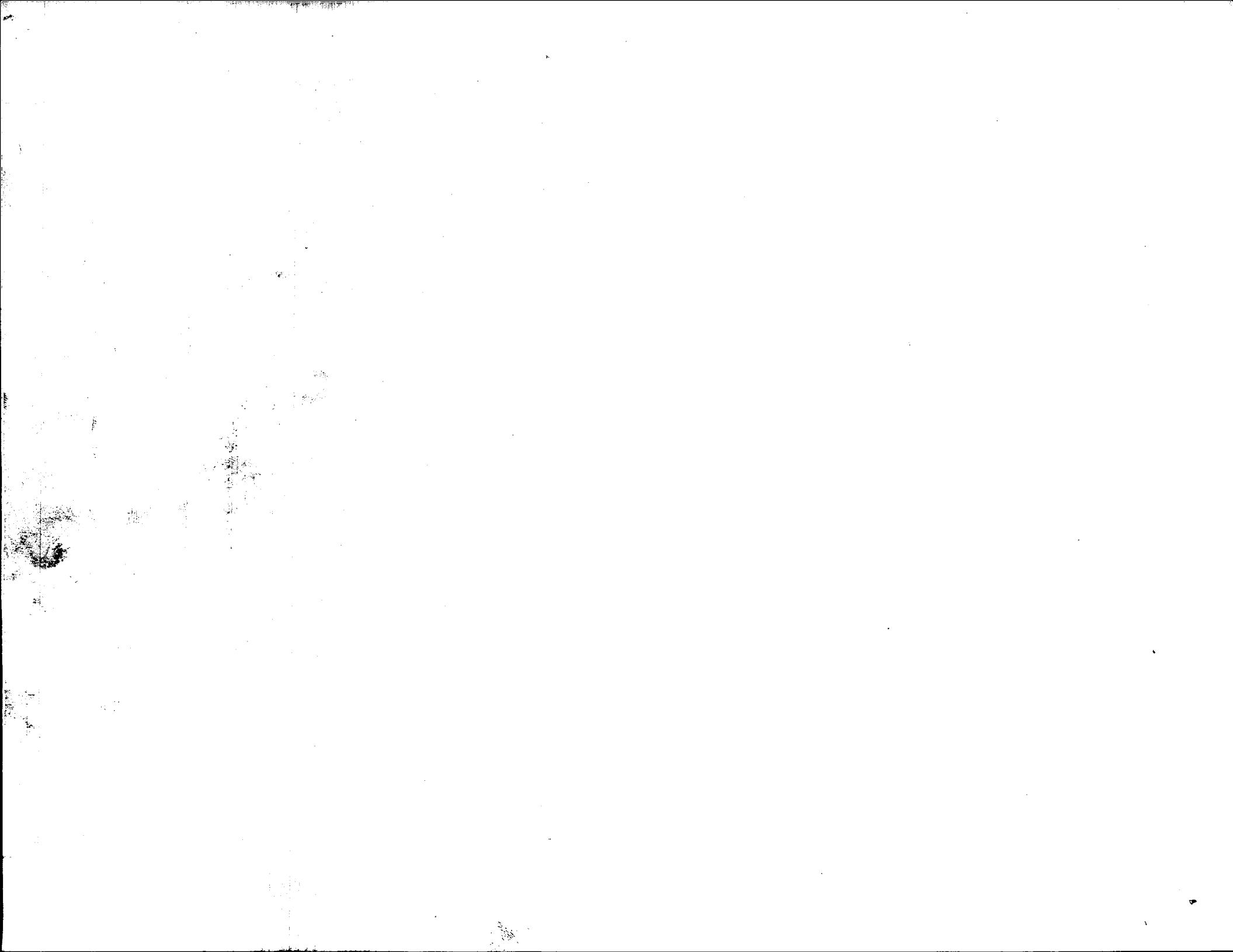
DART AEROSPACE LTD	Work Order:	35328
Description: Step Support Bracket	Part Number:	D2362-3
Inspection Dwg: D2362 Rev: E1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

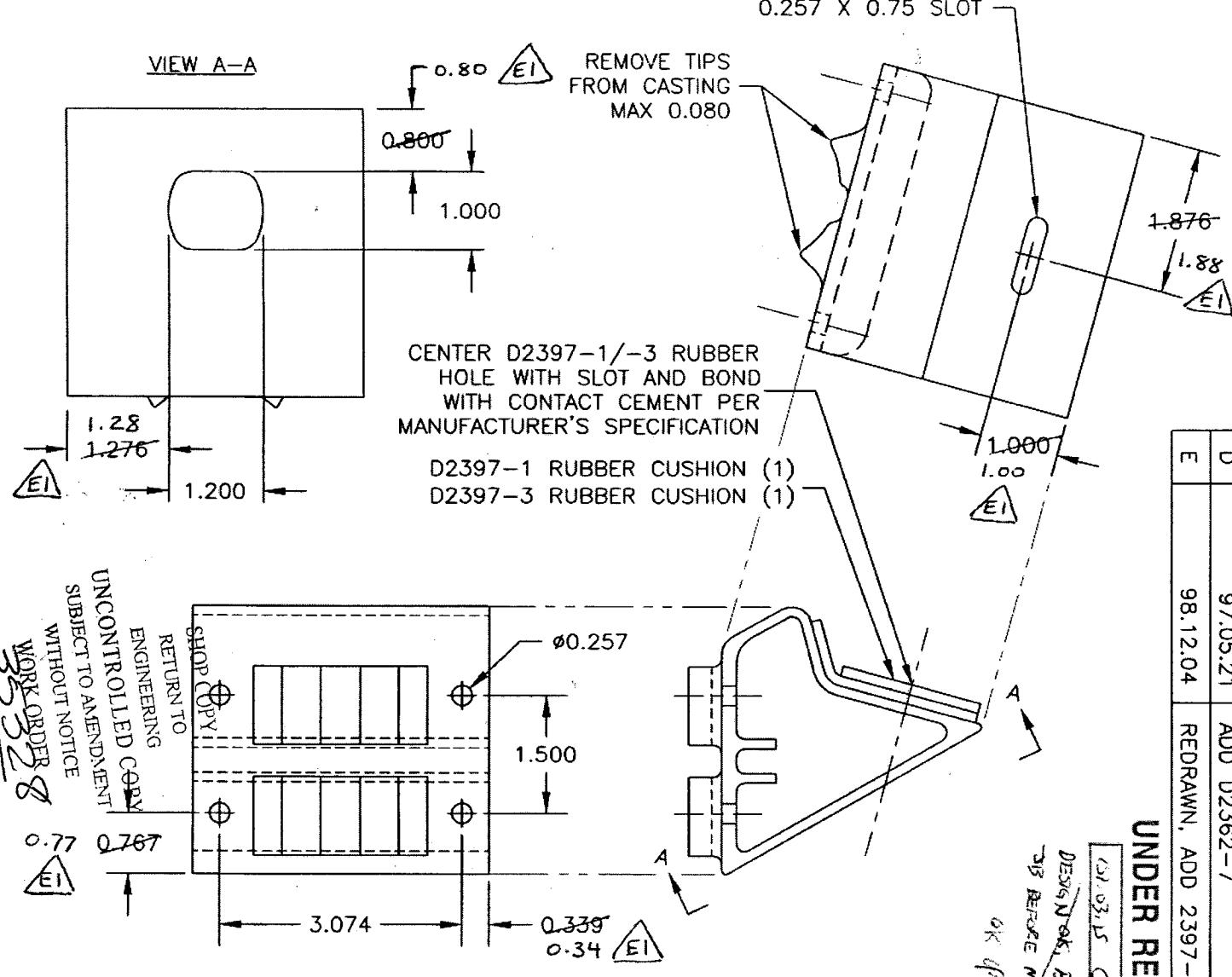
X First Article Prototype

Measured by:	J.L.	Audited by:	S.F.	Prototype Approval:	N/A
Date:	07/11/28	Date:	07/12/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF	FF



EI 03.10.07 TOLERANCE CHANGE ~~REF~~



DESIGN BW	DRAWN BY <i>GP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHEKKED KE	APPROVED <i>KE</i>	DRAWING NO. D2362
DATE 98.12.04	STEP SUPPORT BRACKET	REV. E SHEET 1 OF 3
A	95.02.15	NEW ISSUE
B	95.03.22	CHANGED RUBBER TO D2397
C	96.01.22	ADD D2362-5
D	97.05.21	ADD D2362-7
E	98.12.04	REDRAWN, ADD 2397-5

UNDER REVIEW

CP

DESIGN OK, BUT CHECK WITH
3B BEFORE MANUFACTURE

OK
CP 09.11.97

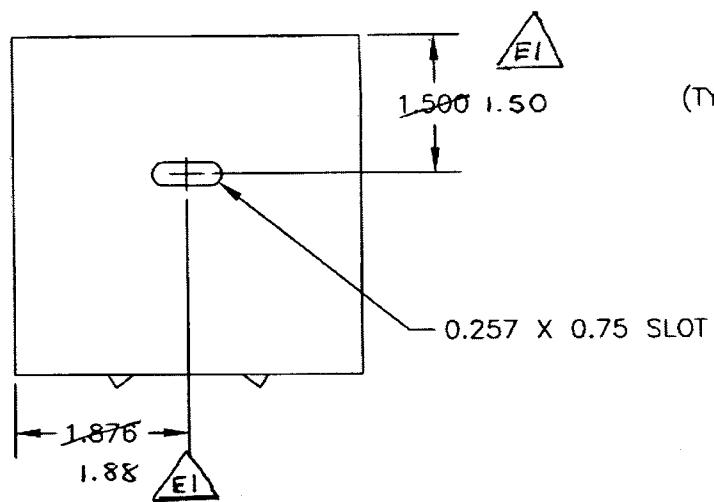
NOTES:

MAKE FROM D2265

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING
RUBBER IN PLACE

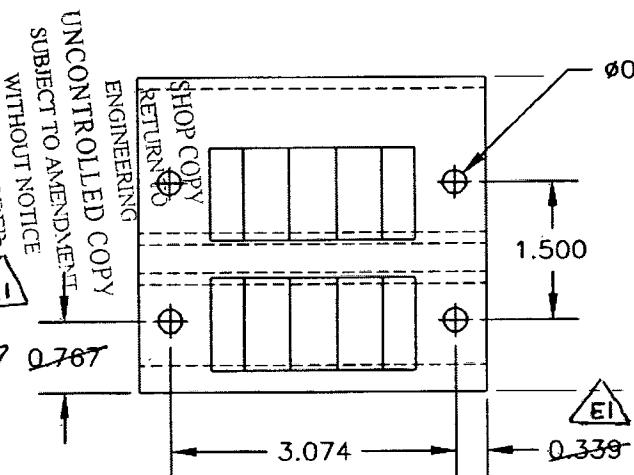
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

VIEW A-A



MACHINE TO
R1.100
(TYP 2 PLACES)

REMOVE TIPS
FROM CASTING
MAX 0.080



BLACK ANTI-SKID PAINT FOR D2362-1
INSTALL D2397-5 (1) FOR D2362-5

D2362-1 & D2362-5

NOTES:

MAKE FROM D2265

D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT
AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3
BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

©A COPY IS
MADE

DESIGN BW	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>RE</i>	APPROVED <i>JF</i>	DRAWING NO. D2362
DATE 98.12.04	TITLE STEP SUPPORT BRACKET	REV. E SHEET 2 OF 3 SCALE 1:2

**RELEASED
UNDER REVIEW**

12/14/98
DRAWINGS CP
DESIGNER, BUD GATECK AND
JTB BEFORE MANUFACTURE
OK
CP 9.1.09

D2362-041 (SHOWN)

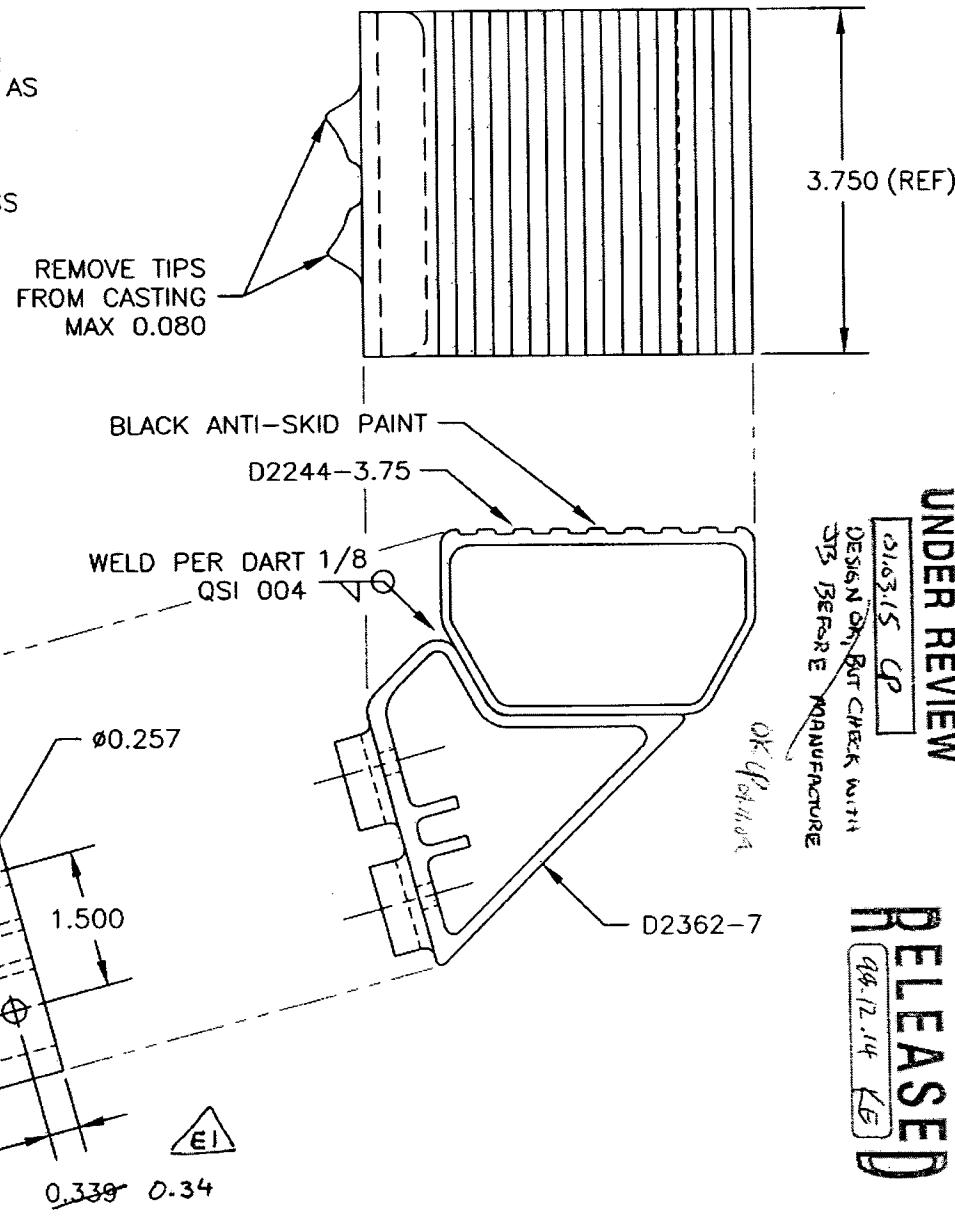
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER
QSI 005 4.3
ANTI-SKID PLANT PER QSI 005 4.4 AFTER
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)

MAKE FROM D2265 CASTING. DRILL D2265 AS
SHOWN IN D2362-041 ASSEMBLY

NOTES:

TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED



DART

OACOPY IS
COPY

DESIGN <i>RE</i>	DRAWN BY <i>GJ</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>RE</i>	APPROVED <i>M</i>	DRAWING NO. D2362
DATE 98.12.04	STEP SUPPORT BRACKET	SHEET 3 OF 3 SCALE 1:2

UNDER REVIEW

RELEASED

01.03.15 CP
DESIGN OK, BUT CHECK WITH
DTS BEFORE MANUFACTURE

44.12.14 K6